

Work Order ID 136480

Thursday, September 03, 2015 7:29:21 AM

136480

Page 1

Item ID: D2893-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support

Start Date: 9/1/2015

Start Qty: 10.00

10

Cust Item ID:

Required Date: 9/1/2015

Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: MLSDate: SEP 04 2015

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2893

C

100

0.01

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.09

HAAS CNC vertical machine #1

1-Machine as per Folio FA081
2-Deburr

30

~~0~~

JFC 2015-10-22

DAS

20

9-89

15-01-03

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

30

~~0~~

DAS

20

9-89

15-11-03

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

30

~~0~~

DAS

44

9-89

15/11/06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Work Order ID 136480

Thursday, September 03, 2015 7:29:21 AM

136480

Page 2

Item ID: D2893-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Support

Stop ***NS2***

Start Date: 9/1/2015 Start Qty: 10.00

10

Cust Item ID:

Required Date: 9/1/2015 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							DAS 41 9-09
130						30			15-11-9
HandFXtube	Memo	0.00							
Hand Finishing Crosstubes	Per note 8 on page 1 of dwg D2893, Prep inner concave surface of support and apply 3M Scotch-Weld as per dwg. 24h of cure time. 132391								
140	QC3- Inspect Part Finish	0.00							DAS 38 9-09
140						30			NOV 10 2015
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>LG50</u>	0.00							DAS 41 9-09
170						30			15-11-10
Packaging	Memo	0.00							
Packaging	LOCATION : <u>LG052</u>								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

Work Order ID 136480***136480***

Page 3

Thursday, September 03, 2015 7:29:21 AM

Item ID: D2893-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Support
Start Date: 9/1/2015 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 9/1/2015 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.02							
Quality Control									

MLJ NOV 10 2015

MLJ NOV 10 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

Thursday, September 03, 2015 7:29:24 AM

Page 1

Work Order ID: 136480

136480

Parent Item: D2893-1

D2893-1

Parent Item Name: Support

Start Date: 9/1/2015

Required Date: 9/1/2015

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP: C02.11.26Reformat; Added P/OKJ

IPP D 06.04.19 removed alodine EC

IPP Rev:E Added priming as per Rev B 07-04-30 JLM

IPP F 08.03.19 Re-format EC verified by: DD

IPP Rev:G 08-05-15 add QC14 DD verified by:EC

IPP Rev:H

11.08.04 as per dwg rev.C DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078		Manufactured	No			100	Each	1.0000	0.5	5.263158			

DSK078

D2893-1 Turning Detail

Location

Loc Qty

Loc Code

MAT060

1

130615

1

136575

1
14

JFC 2015-10-19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

DART AEROSPACE LTD		Work Order: 136480
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.996	2.996	2.998	2.998	2.997
AB	0.440	0.460		.400	.400	.450	.450	.450
AC	0.125	0.160		.128	.130	.133	.134	.130
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.135	.134	.134	.137	.133
AG	0.140	0.160		.149	.150	.149	.148	.149
AH	1.360	1.400		1.378	1.379	1.385	1.382	1.382
AI	0.040	0.060		.052	.053	.050	.052	.053
AJ	1.190	1.230		1.220	1.222	1.224	1.223	1.223
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.525	2.531	2.528	2.527	2.528
AO	84.39	90.39		87.390	87.390	87.390	87.390	87.390
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	DAS 20 9-89	Date: 15-10-26
Audited by:	44 9-89	Date: 15/11/06
Preliminary Approval:		Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	136480
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6 ϕ	7 ϕ	8 ϕ	9 ϕ	10 ϕ
HAAS Section								
AA	2.985	3.005		2.997	3.000	3.000	2.998	2.997
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.135	.130	.132	.133	.134
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.135	.135	.132	.130	.133
AG	0.140	0.160		.149	.151	.150	.148	.149
AH	1.360	1.400		1.382	1.381	1.382	1.380	1.383
AI	0.040	0.060		.053	.051	.050	.055	.050
AJ	1.190	1.230		1.222	1.221	1.223	1.225	1.222
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.525	2.522	2.526	2.525	2.525
AO	84.39	90.39		87.390	87.390	87.390	87.390	87.390
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	DAS 20 9-89	Date:	15-10-27
Audited by:	DAS 43 9-89	Date:	15/11/06
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 136480
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	11 #	12 #	13 #	14 #	15 #
HAAS Section								
AA	2.985	3.005		2.997	2.998	2.999	3.000	3.000
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.130	.133	.135	.136	.130
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.133	.133	.132	.132	.133
AG	0.140	0.160		.149	.149	.149	.150	.149
AH	1.360	1.400		1.381	1.384	1.380	1.382	1.383
AI	0.040	0.060		.053	.050	.052	.049	.049
AJ	1.190	1.230		1.223	1.223	1.223	1.220	1.223
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.525	2.525	2.525	2.525	2.525
AO	84.39	90.39		87.390	87.390	87.390	87.390	87.390
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								

Accept/Reject

DAS
20
9-89

Measured by:	Date: 15-10-28
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Audited by:	Date: 15/11/06
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Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 136480
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16 #	17 #	18 #	19 #	20 #
HAAS Section								
AA	2.985	3.005		3.000	2.997	2.999	2.997	2.998
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.130	.130	.132	.135	.133
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.135	.135	.134	.134	.133
AG	0.140	0.160		.149	.148	.150	.152	.151
AH	1.360	1.400		1.380	1.384	1.379	1.379	1.383
AI	0.040	0.060		.049	.051	.051	.054	.049
AJ	1.190	1.230		1.220	1.224	1.220	1.222	1.222
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.390	87.390	87.390	87.390	87.390
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	DAS 20 9-89	Date:	15-10-29
Audited by:	DAS 44 9-89	Date:	15/11/06
Preliminary Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order: 136480
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	21 ϕ	22 ϕ	23 ϕ	24 ϕ	25 ϕ
HAAS Section								
AA	2.985	3.005		2.999	3.000	3.000	3.000	2.998
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.132	.130	.135	.133	.130
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.134	.134	.132	.133	.133
AG	0.140	0.160		.151	.150	.152	.148	.148
AH	1.360	1.400		1.382	1.382	1.382	1.378	1.381
AI	0.040	0.060		.052	.050	.0515	.051	.0515
AJ	1.190	1.230		1.220	1.222	1.221	1.2185	1.2215
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.390	87.390	87.390	87.390	87.390
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	DAS 20 9-89	Date: 15-11-02
Audited by:	DAS 44 9-89	Date: 15/11/06
Preliminary Approval:		Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	

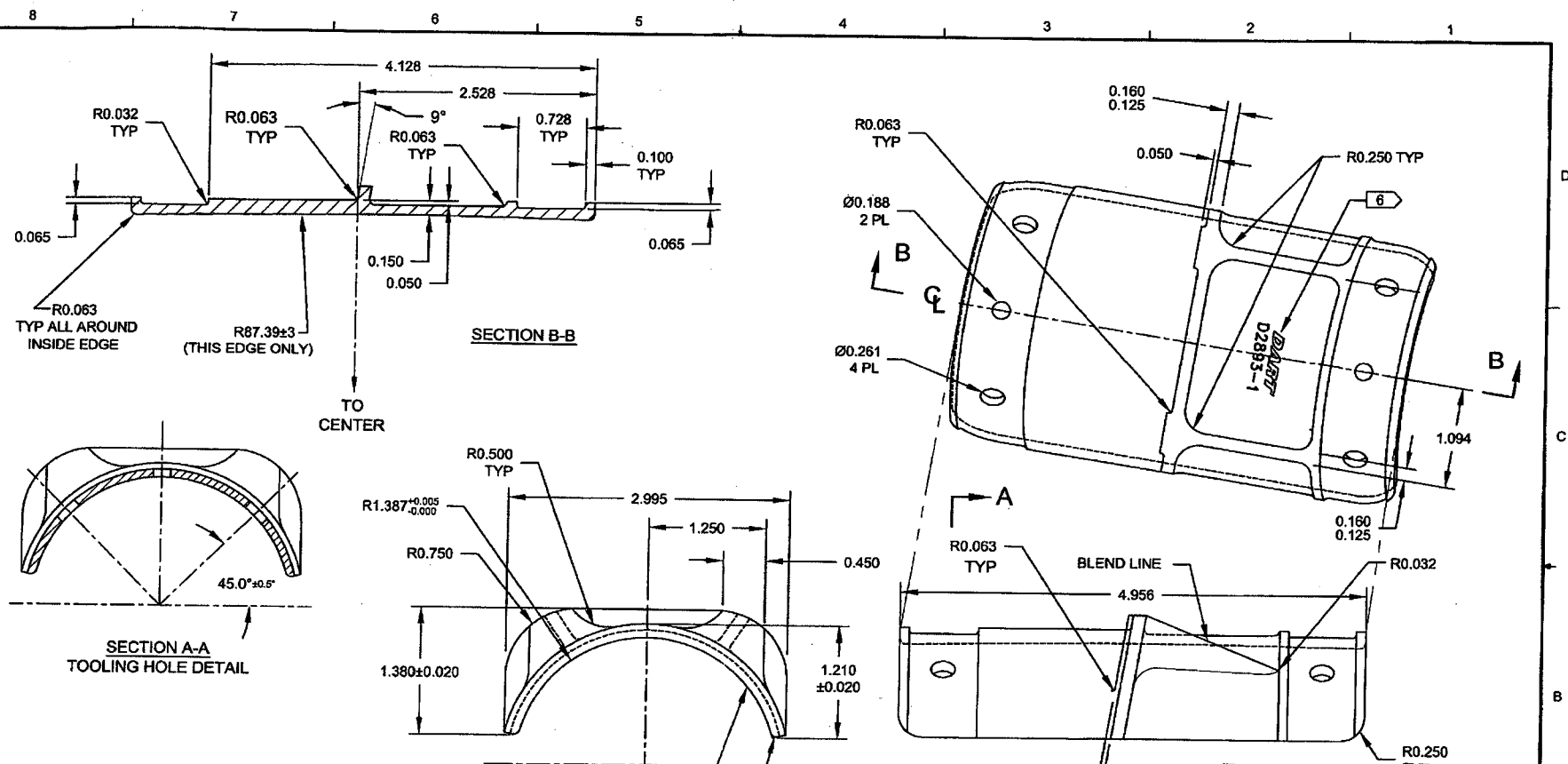
DART AEROSPACE LTD		Work Order: 136480
Description: Ø2.750 Support		Part Number: D2893-1
Inspection Dwg: D2893	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	26#	27#	28#	29#	30#
HAAS Section								
AA	2.985	3.005		3.000	3.000	3.000	3.000	3.000
AB	0.440	0.460		.450	.450	.450	.450	.450
AC	0.125	0.160		.130	.133	.132	.133	.133
AD	0.040	0.060		.050	.050	.050	.050	.050
AE	0.188	0.193		.189	.189	.189	.189	.189
AF	0.125	0.160		.132	.134	.133	.131	.133
AG	0.140	0.160		.150	.150	.1485	.151	.150
AH	1.360	1.400		1.380	1.381	1.380	1.383	1.381
AI	0.040	0.060		.053	.052	.052	.050	.050
AJ	1.190	1.230		1.222	1.221	1.222	1.223	1.220
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AO	84.39	90.39		87.390	87.390	87.390	87.390	87.390
AP	0.261	0.266		.261	.261	.261	.261	.261
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	DAS 20 9-89	Date: 15-11-02
Audited by:	DAS 44 9-89	Date: 15/11/06
Preliminary Approval:		Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	
D	12.07.31	Dwg Rev updated	KJ	



- NOTES:**
- 1) MATERIAL: 17-4 PH STAINLESS STEEL, H900 OR H925 CONDITION
MIN UTS = 170 KSI (38 HRC)
(REF DART SPEC. D8104)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 (REF X.XXX = ±0.010) UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: DART LOGO (PER DART SUPPLIED GRAPHIC) AND PART NUMBER IN THIS AREA WITH 0.125 HIGH LETTERING
0.010-0.020 DEEP, PER DART QSI 044 6.3.

- 7) WEIGHT: 0.78 lb
- 8) FOR THE ENTIRE INNER CONCAVE SURFACE:
ABRADE SURFACE WITH 400-GRIT SANDPAPER. REMOVE RESIDUE WITH MEK
(OR EQUIVALENT). APPLY 0.03" TO 0.05" THICK LAYER OF 3M SCOTCH-WELD 2216 B/A
ADHESIVE TO MATING SURFACE OF SUPPORT. ALLOW TO CURE FOR 24 HOURS.

D2893-1 SUPPORT

C	RMV FINISH, ADD 3M 2216, ADD H925 MAT'L OPTION	CP	11.07.15
B	UPDATE DIMS AS MFG, PRIME INSIDE	PH	07.03.16
A	NEW ISSUE	CP	01.01.10
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.15		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2893 REV. C SHEET 1 OF 1 TITLE: 02.750 SUPPORT SCALE: NTS COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

136480 MLO

1509-04